



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D350-591-312
Job Sheet 173053



Part No: D350-591-312

Job Qty: 10 ea

Part Name: Heli-Access-Step™ RH - High Gear, Long Step, Aerazur Float Compatible



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/26/18

Job Tracking No:

Due Date: 3/30/18

Created By: Michelle Gagnon-Donovan

Type: Stock

Description:

Note: DWG REV B IPP Rev:A 04.03.22 New issue KJ/RF IPP Rev:B 07-06-09 Added D3572-1 JLM IPP Rev:C 08-04-02 ECN1163 DD verified by:EC IPP Rev:D 08-04-08 ECN1164 DD verified by:EC IPP Rev:D fixe route seq in bom DD 10.04.28 verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea	3/28/18	0.00	0.00		Start Up Large Fab-4		SL
110	Large Fab	10 pcs	3/29/18	0.00	10.00		Large Fab 2		SL
120	QC	10 pcs	3/29/18	0.00	0.00		QC9		CPC
130	QC	10 pcs	3/29/18	0.00	0.00		QC5		CPC
140	HandFinish	10 pcs	3/29/18	0.00	1.87		HandFinish1		SA 18-07-07
150	QC	10 pcs	3/29/18	0.00	0.00		QC7-2		CPC
180	Large Fab	10 pcs	3/29/18	0.00	10.00		Large Fab 2		SL 4 DAS
190	QC	10 pcs	3/29/18	0.00	0.00		QC10		DAS 38
200	QC	10 pcs	3/29/18	0.00	0.00		QC5		38 9-88
210	HandFinish	10 pcs	3/29/18	0.00	1.87		HandFinish1		SA 18-3-22
220	Powdercoat	10 pcs	3/29/18	0.00	2.98		Powdercoat1		BR 18-3-22
230	HandFinish	10 pcs	3/30/18	0.00	1.87		HandFinish3		DAS
240	QC	10 pcs	3/30/18	0.00	0.00		QC3		38
250	Packaging	10 pcs	3/30/18	0.00	0.00		✓ Packaging1-3		9-88
260	QC	10 pcs	3/30/18	0.00	0.00		QC4		M. AD.
265	DC	10 pcs	3/30/18	0.00	0.00		DC		M. AD.
270	Packaging	10 pcs	3/30/18	0.00	0.00		Packaging3-1		DAS
280	QC21-FG	10 Ea	3/30/18	0.00	0.00		QC21		21

Part Op 110 - 1-Bevel end for welding FWD ONLY 2-Weld Support using Jig DT10115, Weld FWD End Plate as per QSI 004 & Dwg Descriptions: D3272 A/R Aluminum Rod M138673 3-Grind End Plate flush

180 - 1-Assemble Leg Assembly as per Dwg D3272. 2-Leave one rivet out until welding is complete. 3-Bevel Aft end for welding 4-Inspect for foreign object as per QSI 024 5-Weld Aft End Plate as per QSI 004 & Dwg D3272 A/R Aluminum Rod M138673 6-Grind End Plate flush 7-Install last rivet as per Dwg. M158760

220 - START TIME: 12:00 OVEN TEMPERATURE: 320 FINISH TIME: 12:30

265 - Photocopy bluefile and type labels as per PPP D350-591-312 CHG001

270 - Identify and pack for shipping as per PPPD350-591-312 Location :FG072

001394

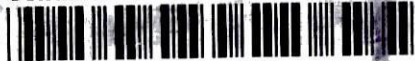
Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
D3067-1	End Plate	20 Ea (2 ea)	90-Start up Operation	50476060
D3219-1	Plate	20 Ea (2 ea)	90-Start up Operation	50476027
D3272-1	Step	10 Ea (1 ea)	90-Start up Operation	5047130
D3065-041	Step Leg Assembly	10 Ea (1 ea)	180-Large Fab	5046489/5053119
D3066-1	Spacer	20 Ea (2 ea)	180-Large Fab	5053118
MS20600-AD4W4	Rivet	160 Ea (16 ea)	180-Large Fab	505785053116
AN3-35A	Bolt	20 Ea (2 ea)	250-Packaging	5047337
AN4-13A	Bolt	80 Ea (8 ea)	250-Packaging	5045860
AN5-36A	Bolt	20 Ea (2 ea)	250-Packaging	5044116
D2230-3	Mounting Lug	40 Ea (4 ea)	250-Packaging	5051382x12//5049159x20
D2618	Bushing	20 Ea (2 ea)	250-Packaging	5043411
D2856-400	Abrasion Strip 4" Wide (Per Foot)	12 Ea (1.2 ea)	250-Packaging	5051490
D3235-1	Mounting Lug	20 Ea (2 ea)	250-Packaging	5049171
D3278-041	Support Assembly	10 Ea (1 ea)	250-Packaging	5053036
MS21042L3	Nut	20 Ea (2 ea)	250-Packaging	5038764
MS21042L4	Nut	80 Ea (8 ea)	250-Packaging	5045901
MS21042L5	Nut	20 Ea (2 ea)	250-Packaging	5016880
NAS1149D0363J	Washer	40 Ea (4 ea)	250-Packaging	5015269
NAS1149D0463J	Washer	160 Ea (16 ea)	250-Packaging	5045845
NAS1149D0563J	Washer	40 Ea (4 ea)	250-Packaging	5025743
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D3067-1	20	23	0
	D3219-1	20	44	0
	D3272-1	10	0	0
180-Large Fab	D3065-041	10	12	0
	D3066-1	20	30	0
	MS20600-AD4W4	160	1,841	0
250-Packaging	AN3-35A	20	122	0
	AN4-13A	80	467	0
	AN5-36A	20	148	0
	D2230-3	40	65	0
	D2618	20	234	0
	D2856-400	12	95	0
	D3235-1	20	14	0
	D3278-041	10	8	0
	MS21042L3	20	3,411	0
	MS21042L4	80	998	0
	MS21042L5	20	877	0
	NAS1149D0363J	40	3,425	0
	NAS1149D0463J	160	2,258	0
	NAS1149D0563J	40	1,330	0
Part Specifications				
Specifications could not be found.				

Plex 2/26/18 8:40 AM Dart.Gagnon.Michelle



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL.: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S048030



Part: D350-591-312

Job No: 173053

Serial No/Batch: S048030

Revision:

Inspector:

Date: 03/05/18

Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X						D350-591-213	<i>Hel-Access-Step™</i> , Short Step – High Skid, LH
	X					D350-591-214	<i>Hel-Access-Step™</i> , Short Step – High Skid, RH
		X				D350-591-215	<i>Hel-Access-Step™</i> , Short Step – Low Skid, LH
			X			D350-591-216	<i>Hel-Access-Step™</i> , Short Step – Low Skid, RH
				X		D350-591-311	<i>Hel-Access-Step™</i> , Long Step – High Skid, LH
					X	D350-591-312	<i>Hel-Access-Step™</i> , Long Step – High Skid, RH
1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
	1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
		1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
			1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
				1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
					1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
2	2	2	2	4	4	D2230-3	MOUNTING LUG
2	2	2	2	2	2	D2618	BUSHING
4	4	4	4			D2732-030	CUSHION
				2	2	D2856-400-720	ABRASION STRIP
2	2	2	2	2	2	D3235-1	MOUNTING LUG
				1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	AN3-35A	BOLT
				8	8	AN4-13A	BOLT
4	4	4	4			AN4-15A	BOLT
2	2	2	2	2	2	AN5-38A	BOLT
4	4	4	4	4	4	NAS1149D0363J	WASHER (AN960JD10)
12	12	12	12	16	16	NAS1149D0463J	WASHER (AN960JD416)
4	4	4	4	4	4	NAS1149D0563J	WASHER (AN960JD516)
2	2	2	2	2	2	MS21042L3	NUT
6	6	6	6	8	8	MS21042L4	NUT
2	2	2	2	2	2	MS21042L5	NUT
				1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 15 for installation of the DSI 9410-011 Kit.